

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch

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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-002487**Date Inspected:** 15-May-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 630**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1530**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Fu Yu Hong**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

CALTRANS Quality Assurance (QA) Inspector, Alfredo Acuna was present for the fabrication scheduled for this project at the ZPMC facility in Shanghai, China for the San Francisco Oakland Bay Self Anchored Suspension Bridge.

The QA inspector performed 10 % ultrasonic testing (UT) at the completed joint penetration on weld joints: SEG-015-001 (side plates connections between SP10A and SP18A), SEG-017-003 (Bottom plates connections BP-013 and BP-014), SEG 017-005 (side plates connections SP-72A and SP-60A), SEG 017-001 (side plates connections SP-11/SP-19A), SEG 015-005 (side plates connections SP-71A SP-59A). The QA inspector found that welds areas tested appeared to be in compliance with the contract documents. However, several joints had class A indications reflected from the weld profile that could mask relevant indications. The QA inspector had a conversation with Caltrans Task Leader David McClary and ZPMC representative Shen Xu Jun. The QA inspector informed Mr. David McClary and Mr. Shen Xu Jun that class A indications reflected from the weld profile were found. Mr. David McClary and ZPMC representative agreed with grinding the areas where class A indications were found. The QA inspector found the welds in compliance with the contract documents after ZPMC ground the weld profile. See UT report TL\_6027 generated on this date.

The QA inspector performed 10 % ultrasonic testing (UT) on the completed joint penetration at weld joints: SA107 B/J-16A skin plate connections. The QA inspector found that welds areas tested appeared to be in compliance with the contract documents. See UT report TL\_6027 generated on this date.

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## WELDING INSPECTION REPORT

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### Summary of Conversations:

As noted above.

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Mazen Wahbeh, (818) 292-0659, who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Acuna,Alfredo
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Quality Assurance Inspector
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<b>Reviewed By:</b>	Cuellar,Robert
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QA Reviewer
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